

Date: Monday, 3/26/2007 3:22:23 PM
 User: Kim Johnston

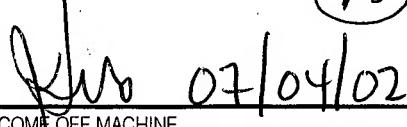
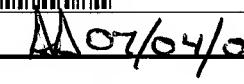
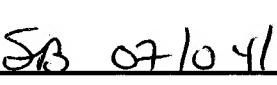
Process Sheet

Customer	CU-DAR001 Dart Helicopters Services	Drawing Name	WEARPAD
Job Number	31473		
Estimate Number	12712		
P.O. Number	N/A	Part Number	D35371
This Issue	3/26/2007	S.O. No.	N/A
Prsht Rev.	NC	Drawing Number	D3537 REV A
First Issue	N/A	Project Number	N/A
Previous Run	31163	Drawing Revision	A
Written By		Material	N/A
Checked & Approved By	<u>ML 07/04/02</u>	Due Date	4/6/2007
Comment	Est Rev:A New Issue 07-02-14 JLM	Qty:	10
Um:	Each		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description:
1.0	M304S16GA	304/316 .063 Sheet
		
	Comment: Qty.: 0.0788 sf(s)/Unit Total : 0.7875 sf(s) M304S16GA .063" 304 SS SHEET Batch: M19052	<u>ml 07 04 02</u> 
2.0	WATER JET	FLOW WATER JET
		
	Comment: FLOW WATER JET 1-Cut as per Dwg D3537	<u>ml 07 04 02</u> 
	Dwg Rev: <u>A</u> Prog Rev: <u>A</u>	<u>ml 07 04 02</u> 
	2-Deburr if necessary	<u>ml 07 04 02</u> 
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
		
	Comment: INSPECT PARTS AS THEY COME OFF MACHINE	<u>ml 07 04 02</u> 
4.0	QC8	SECOND CHECK
		
	Comment: SECOND CHECK	<u>ml 07 04 02</u> 
5.0	BRAKE NC	NC BRAKE
		
	Comment: NC BRAKE 1-Form as per Dwg D3537 on CNC brake using Jigs DT 8261 and DT 8326. 2-Identify as D3537-1	<u>ml 07 04 02</u> 

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA:  Date: 07/04/05
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 3/26/2007 3:22:23 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARPAD

Job Number: 31473

Part Number: D35371

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Qty	Description	Batch
A/R	2059B Hardcoat	M102755

FC 07/04/03 (9)

PTU

1-Weld as per Dwg D3537 using Jig DT 8210

2-Remove any weld that penetrated through Wearpadif necessary

7.0 QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

07/04/03 (9)

8.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

07/04/03 (9)

9.0 POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

FC 07/04/04 (9)

10.0 QC3

INSPECT POWDER COAT/ CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/ CHEMICAL CONVERSION

07/04/05 (9)

11.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock
Location: _____

07/04/05 (9)

12.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07/04/05 (9)

Job Completion



07/04/05 (9)

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
070404	6.0	1 part used for weld test, per Bill's request.	FC	07 04 04	1	070404	070404	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	31473
Description: Wearpad	Part Number:	D3537-1
Inspection Dwg: D3537	Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

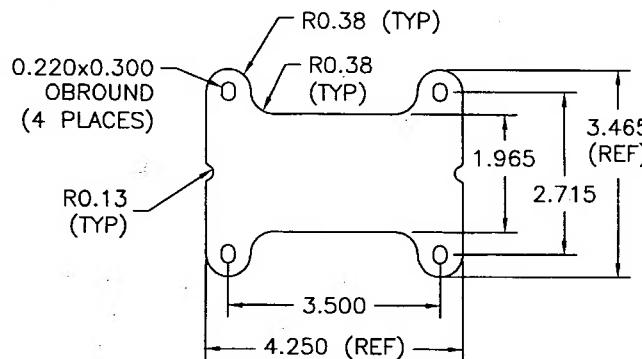
Measured by:	M.M
Date:	07/04/02

Audited by:	
Date:	07/04/02

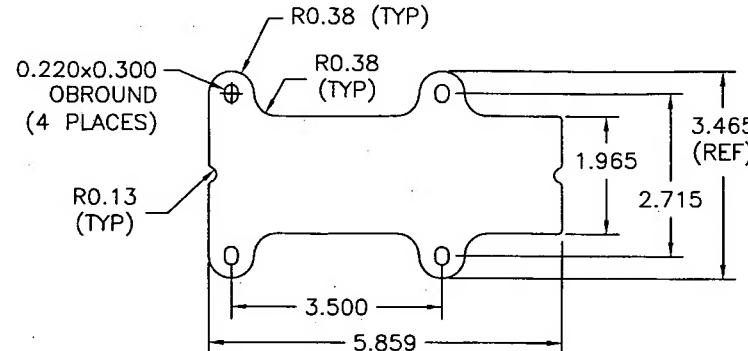
Prototype Approval:	N/A
Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.03.21	New Issue	KJ/JLM <i>AS</i>	<i>RE</i>

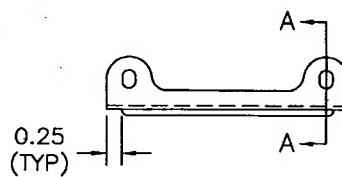
D3537-1F FLAT PATTERN



D3537-3F FLAT PATTERN



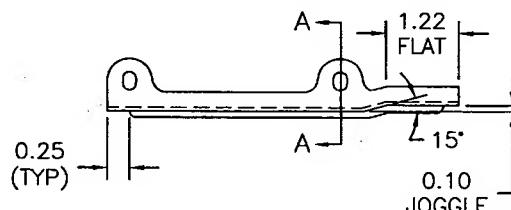
D3537-1 LONGITUDINAL BEND (MADE FROM D3537-1F)



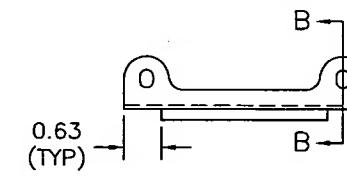
RELEASED

07.02.12

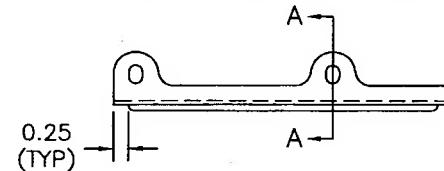
D3537-3 LONGITUDINAL BEND (MADE FROM D3537-3F)



D3537-5 LONGITUDINAL BEND (MADE FROM D3537-1F)



D3537-7 LONGITUDINAL BEND (MADE FROM D3537-3F)



NOTES

- 1) MATERIAL: AISI 304/316 SS SHEET, 16 GAUGE (0.063 THICK, REF DART SPEC. M304S16GA)
- 2) BREAK ALL SHARP CORNERS 0.063 MAX
- 3) WELD PER QSI 004
- 4) FINISH: POWDER COAT GREY SANTEX (4.3.5.6) PER QSI 005
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

NO. 314
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER 12
UNCONTROLLED COPY
ENGINEERING
RETURN TO
SHOP COPY
DRAFT SPEC. M304S16GA

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A	06.11.06	NEW ISSUE
DESIGN	DRAWN BY	DART AEROSPACE USA, INC. PORT HUROCK, VA
CHECKED	APPROVED	DRAWING NO.
PH	PH	D3537
DATE	TITLE	SCALE
06.11.06	WEARPAD	1:2